



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6510G04631-6F-8
Job Sheet 199039



Part No: RBW6510G04631-6F-8

Job Qty: 2 pcs

Part Name: Bracket Pin



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/9/19

Job Tracking No:

Due Date: 10/21/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6510G04631-6F Rev A IPP Rev. A 19.08.08 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter / Supplier Lead Time	Sign-off
					Setup Hrs	Run Hrs		
100	SL-154 - 1	2 pcs	10/21/19	10/21/19	1.00	0.40	SL-154 - 1	
110	QC 2	2 pcs	10/21/19	10/21/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
							QC 2 - 65	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S218069



Part: RBW6510G04631-6F-8

Job No: 199039

Serial No/Batch: S218069

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 09/28/19

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120	QC 8	2 pcs	10/21/19	0.00 0.00	QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	mkl 19/09/30
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
130	Outsource - 12 - Black Oxide	2 pcs	10/21/19		GRO002-VC	18209-10-01
140	Packaging 2-1 - Receive - B4B	2 pcs	10/21/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	R OCT 04 2019
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
150	QC 6	2 pcs	10/21/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	

				QC 6 - 40	DAS 81 9-89	
				QC 6 - 81		OCT 07 2019
160	Packaging 3-1 - Stock - B4B	2 pcs	10/21/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS 28 9-89
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
170	QC 21 - SA	2 pcs	10/21/19	0.00 0.00	QC 21 - SA - 21	DAS 21 9-89
					QC 21 - SA - 70	OCT 08 2019
					QC 21 - SA - 53	
Part Op 100 - 1-Machine as per folio F0005 FOLIO REV: AA DWG REV: A 2-Deburr Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB 120 - QC8- Inspect parts - second check 130 - Issue P/O: 44641 -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required 140 - (Receive & Inspect for Damage & Mat'l Certs) Certificate of Conformity is required 150 - QC6- All purchased or subcontracted products 160 - Identify as per dwg & Stock Location: 170 - QC21- Final Inspection - Work Order Release						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
MT-4140QT-R0.875	MT-4140QT-R0.875	2160 ft (.108 ea)	100-SL-154 - 1	512 4464	2'	
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-SL-154 - 1	MT-4140QT-R0.875	0	29	0		
Part Specifications						
Specifications could not be found.						

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DART AEROSPACE LTD		Work Order:	199039
Description: Reaction Assembly		Part Number:	RBW6510604631-6F-8
Inspection Dwg: Same as Part # Rev: A		Page 1 of 1	

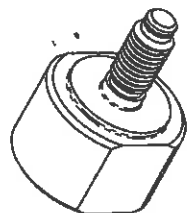
INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1/4-28 NF	N/A	1/4-28 NF	✓		Wire and bolt	
Ø .140	.249 - .2525	.2465	✓		Micrometer	
Wire .024	.2609 - .2636	.265	✓		Micrometer	
Ø .188	± .005	.1886	✓		Micrometer	
Ø .1735	.1735 - .1765	.175	✓		Micrometer	
.045	± .005	.049	✓		optical comparator	
.018	.018 - .022	.021	✓		Caliper	
Ø .11	± .01	.109	✓		Caliper	
.43	± .01	.435	✓		optical comparator	
.61	± .01	.608	✓		Caliper	
.65	± .01	.647	✓		Caliper	
1.198	± .005	1.197	✓		Caliper	
.03 X .45	± .01	.025 X .45	✓		Caliper	
.740	.740 - .752	.747	✓		Micrometer	
Ø .87	± .01	.871	✓		Caliper	
Ø .25	± .01	.249	✓		Caliper	
Ø .63	± .01	.629	✓		Caliper	
.02 X .45	± .01	.024 X .45	✓		Caliper	

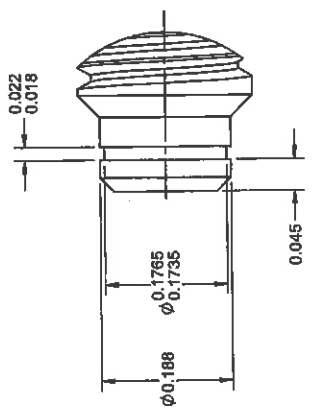
Measured by: <i>DL</i>	Checked by: <i>mf</i>	QC Inspector:
Date: 9/28/2019	Date: 10/09/30	Date:

Engineering Approval: (If necessary)	Date:
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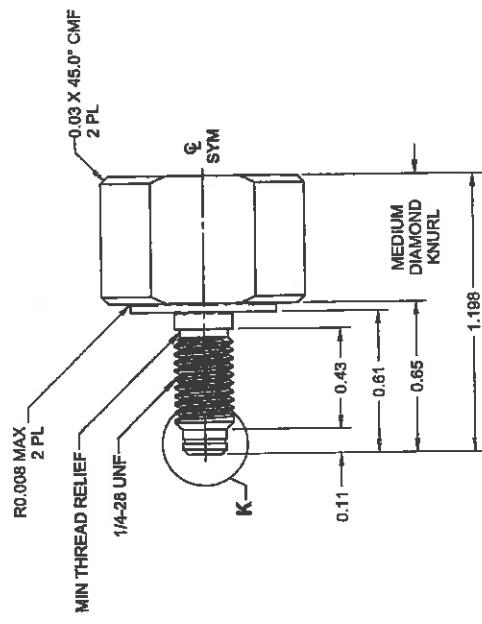
Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	



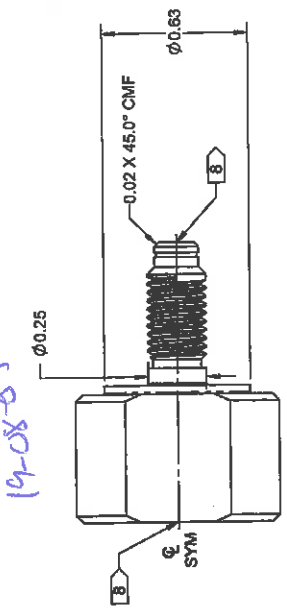
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 199039115
19-08-09



DETAIL K



RBW6510G04631-6F-3 BRACKET PIN



- NOTES:
- 1) MATERIAL: 4140 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-18173 GRADE 3 CLASS 1 OR MIL-C-81308 TYPE III OR MIL-C-23511A OR MIL-PRF-81309 AND WIPE OFF EXCESS
 - 4) TOLERANCES: X.XX = ± 0.01 / $\pm 0.5^\circ$
X.XXX = ± 0.005 / $\pm 0.1^\circ$
X.XXXX = ± 0.0005 / $\pm 0.05^\circ$
PARALLELISM ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005 "
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A
 - 8) CENTER DRILL IS ACCEPTABLE

DESIGN	KPT	TOOL PART #	REV. A
DRAWN	KPT	RBW6510G04631-6F	SHEET 10 OF 10
CHECKED	WM	TITLE	SCALE
MFG. APPR.	PK	REACTION ASSEMBLY	NTS
APPROVED	VP	COPYRIGHT © 2019 BY DART AEROSPACE LTD	THIS DOCUMENT IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE
DATE	2019-07-09		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐
Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____ Sequence #: _____

QTY Affected: _____

MRB (QSI042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge
☐	☐	☐
Bending ☐	Misaligned/off center ☐	Folio/Program ☐
Crushing ☐	BOM/Route ☐	Grain Direction ☐
Cracks ☐	Broken/Damage/Defect ☐	Weld ☐
Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐
Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐
Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐

Other/Details: _____

Positioned Wrong	Outside Tolerance	Drawing	Finish	Part Lost/Missing	Misread
☐	☐	☐	☐	☐	☐



Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044641



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044641

PO Date: 10/1/19

Due Date: 10/9/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-10-02

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	198410	RB 92700-10310-041-3	Plate -Issue P/O: -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	10/9/19	4 pcs	0 pcs	4 pcs	\$5.85/pcs	\$23.40
2	200723	RBW5605G00251-3G-1	Hook -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; O1 -Certificate of Conformity is required	Firmed K9.	-	10/9/19	9 pcs	0 pcs	9 pcs	\$1.34/pcs	\$12.06

OCT 04 2019



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PURCHASE ORDER **POHB044641**



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	199259	RBST4241-9	Pin -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; -Certificate of Conformity is required	Firmed	-	10/9/19	4 pcs	0 pcs	4 pcs	\$1.34/pcs	\$5.36
4	199142	RBW6522A00231-W142AJ-3T-5B	Cover (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	10/9/19	2 pcs	0 pcs	2 pcs	\$1.34/pcs	\$2.68
5	199046	RBW6510G05731-6F-1	Base Plate -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	10/9/19	6 pcs	0 pcs	6 pcs	\$7.85/pcs	\$47.10

10/2/2019

PURCHASE ORDER



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044641



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	199048	RBW6510G05731-6F-3	Reaction Mount -Issue P/O: -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	10/9/19	6 pcs	0 pcs	6 pcs	\$3.28/pcs	\$19.68
7	199039	RBW6510G04631-6F-8	Bracket Pin -Issue P/O: -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	10/9/19	15 pcs	0 pcs	15 pcs	\$1.40/pcs	\$21.00
8	200724	RBW5605G00251-3G-2	Shank -Issue P/O: -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	10/9/19	9 pcs	0 pcs	9 pcs	\$1.53/pcs	\$13.77

Grand Total: \$145.05



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PURCHASE ORDER

POHB044641



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/2/19 9:16 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(022883-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupealtech.com

Bon de Livraison / Packing Slip

022883 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
04-Oct-2019		Jigar Patel		POHB044641					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir / Back Order	
2	RBW5605G00251-3G-1 Rev.	RBW5605G00251-3G-1 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	9	9	0	0	0	RE
7	RBW6510G04631-6F-8 Rev.	RBW6510G04631-6F-8 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	15	15	0	0	0	RE
8	RBW5605G00251-3G-2 Rev.	RBW5605G00251-3G-2 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	9	9	0	0	0	RE

RECEIVED
 OCT 04 2019
 DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.